

Date: Thursday, 7/26/2007 2:41:17 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WINDOW ASSEMBLY  
Job Number : 33753  
Estimate Number : 10304  
P.O. Number : N/A Part Number : D3136043  
This Issue : 7/26/2007 S.O. No. : N/A Drawing Number : D3136 UNDER REVIEW  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : THERMOFORMING Drawing Revision : D  
Previous Run : 32816B Material : N/A  
Due Date : 8/2/2007 Qty: 10 Um: Each  
Written By : [Signature]  
Checked & Approved By : [Signature]  
Comment : Est Rev.A 04.02.04 New issue KJ/DS  
Est Rev.B 07.05.29 Thermoform in-house DL

OK FOR REV D  
07.07.26

## Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 MACRLICS125 1/8" Polycast II Sheet



Comment: Qty.: 3.9000 sf(s)/Unit Total : 39.0000 sf(s)  
polycast II or plexiglass G .125"

M 104546 HB 07-08-1

2.0 WATER JET FLOW WATER JET



REV D  
PRG D

HB 07-08-1



11

Comment: FLOW WATER JET

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 07-08-1



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

car  
Er 07/08/01 (X11)

5.0 THERMOFORMING THERMOFORMING MACHINE



Comment: 1-Thermoform as per Dwg D3136-3 and Folio FTA002

Dwg Rev. D  
Folio Rev. A

07.08.03 (X11)

2- Engrave Part # and Batch # , and affix labels

(P102)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: AD Date: 07/02/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)               |                             |                                 |                                |                                |                                |                                |
|----------|------|--|-----------------------------|---------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|
| DATE     | STEP | Description of NC<br>Section A                 | Corrective Action Section B |                                 |                                | Verification<br>Section C      | Approval<br>Chief Eng          | Approval<br>QC Inspector       |
|          |      |  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date                 |                                |                                |                                |
| 07/02/03 | 50   | do not scrap due to<br>marks from thermocouple | <i>[Signature]</i>          | Scram and no<br>replace         | 07/02/03<br><i>[Signature]</i> | <i>[Signature]</i><br>07/02/03 | <i>[Signature]</i><br>05/10/02 | <i>[Signature]</i><br>07/02/03 |
|          |      |  |                             |                                 |                                |                                |                                |                                |
|          |      |  |                             |                                 |                                |                                |                                |                                |

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW ASSEMBLY

Job Number: 33753

Part Number: D3136043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D31089

Decal



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s) x 22.

Pick:

Qty Part# Description Batch

2 D3108-9 Decal B22608

07.08.03.

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07.08.03.

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.08.03 (X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/08/07 (92)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(9)

07/08/07

Job Completion



07/08/07

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

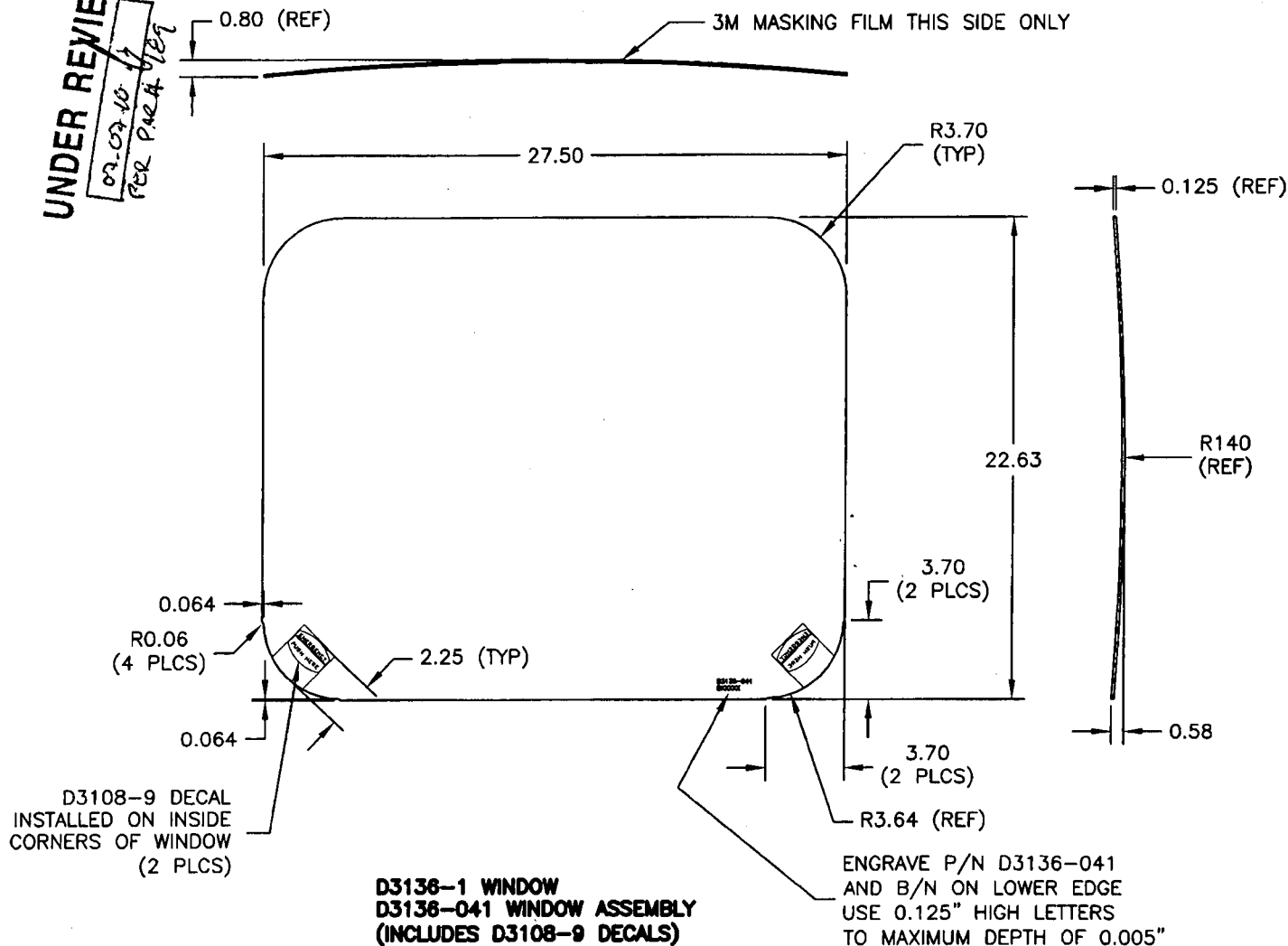
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART****RELEASED**  
05.12.01

|                  |          |   |                        |
|------------------|----------|---|------------------------|
| DESIGN           | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED          | APPROVED | DRAWING NO.<br>D3136                              | REV. D<br>SHEET 1 OF 2 |
| DATE<br>05.12.01 |          | TITLE<br>WINDOW ASSEMBLY                          | SCALE<br>1:8           |
| A                | 02.04.18 | NEW ISSUE   |                        |
| B                | 04.01.21 | ADDED D3136-3 AND D3136-043                       |                        |
| C                | 04.05.05 | ADDED FORMING & ENGRAVING SPEC                    |                        |
| D                | 05.12.01 | UPDATED MATERIAL NOTES                            |                        |

UNDER REVIEW  
02.02.10  
PER PARA 4.1.1**NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F  
b) DRAPE OVER D3136-T1 MOLD & CLAMP  
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS  
d) TRIM PER TEMPLATE D3136-1T2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

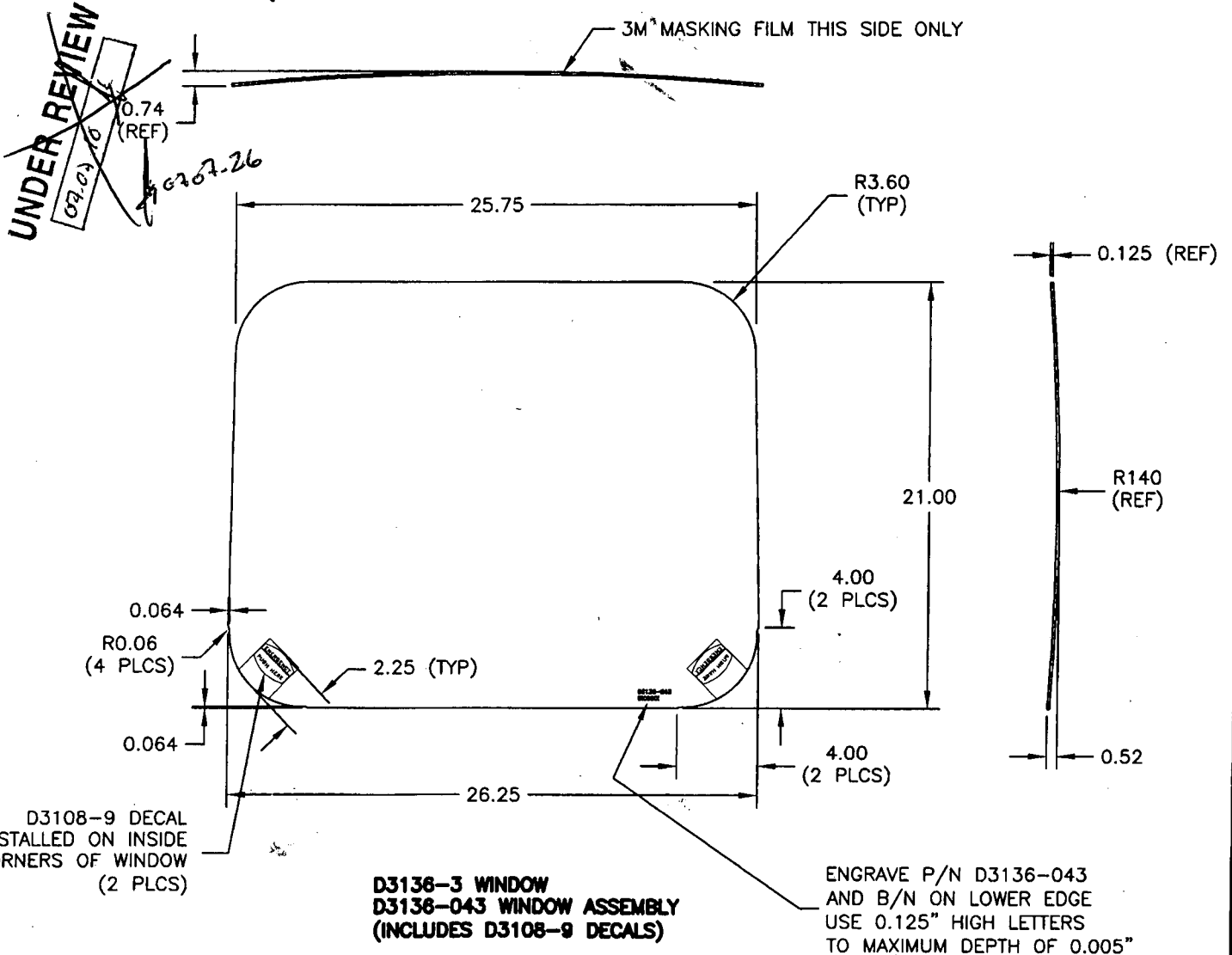
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART**

|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3136                              | REV. D<br>SHEET 2 OF 2 |
| DATE<br>05.12.01              |                                | TITLE<br>WINDOW ASSEMBLY                          | SCALE<br>1:8           |

**RELEASED**  
05-12-01 *[Signature]***NOTES:**

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c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS  
d) TRIM PER TEMPLATE D3136-3T1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

